



Dart Aerospace Ltd.
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C3-C-1

Job Sheet 200761



Part No: C3-C-1

Job Qty: 1 pcs

Part Name: Weldment C3 Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19302

Note: DWG C3-C Rev J IPP Rev A 18.03.28 New issue DP Verify DD/IPP Rev. B 19.04.25 drawing revision DP Verify DD/IPP Rev. C 19.05.03 drawing revision DP Verify DD/IPP Rev. D 19.07.23 drawing update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	10/31/19	10/31/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Oct 15/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/31/19	10/31/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		EL
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
			10/31/19	10/31/19	0.00	0.00	QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		



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Container No: S222165



Part No: C3-C-1

Job No: 200761

Material No/Batch: S222165

Revision: J

Inspector:

Date:

Instructions:

Date: 10/15/19

Plex 9/17/19 1:30 PM Dart.Renwick.Jennifer

9/17/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	AL
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130	Powdercoat - 6 Fire Red - B4B	1 pcs	10/31/19	0.00	0.50	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	3/19-10-17
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	10/31/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	DAS 30 OCT 17 2019
						QC 3 - 34	9-8P
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Packaging 3-1 - Stock - B4B	1 pcs	10/31/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	9-8P OCT 17 2019
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	

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				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	10/31/19	0.00 0.00	QC 21 - SA - 21	OAS OCT 17 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-59

Part Op 100 - 1-Fabricate C3-C-3, C3-C-4 and C3-C-5. 2-TACK WELD FOR INSPECTION BY: EL USE WELDING JIG
 Descriptions: C3-19C. 2-Weld as per DWG. ***See notes 8,9,10 and 11***
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3 START TIME: 8:15 OVEN TEMPERATURE: 320° FINISH TIME: 8:45 11/29/2018
 140 - QC3- Inspect Part Finish Ink stamp will be done on top level assembly.
 150 - 1-Identify as per dwg & Stock Location: 9160 2-Ink stamp will be done on top level assembly, identify with green tag.
 160 - QC21- Final Inspection - Work Order Release

Job BOM

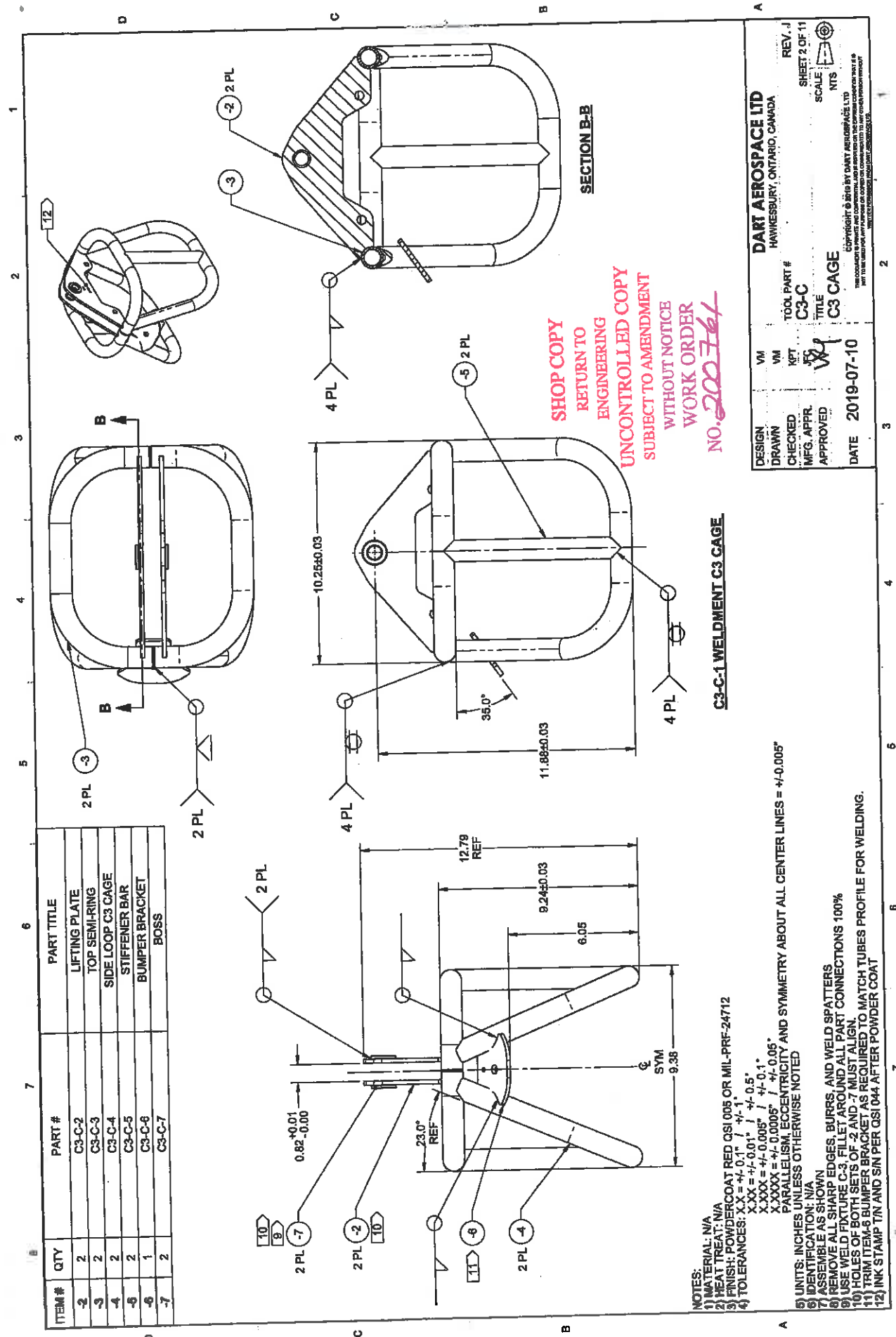
Part / Item	Component Name	Quantity	Operation	Container
C3-C-2	Lifting Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5217546</u>
C3-C-6	Bumper Bracket	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5219520</u>
C3-C-7	Boss	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5181047</u>
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	8.7000 ft (8.7 ea)	100-Large Fab - Welded Assy-1	<u>5190631/5200823</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	C3-C-2	2	0	0
	C3-C-6	1	4	0
	C3-C-7	2	0	0
	MT-A513-T-1.000W0.120	9	163	0

Part Specifications

Specifications could not be found.



ITEM #	QTY	PART #	PART TITLE
-2	2	C3-C-2	LIFTING PLATE
-3	2	C3-C-3	TOP SEMI-RING
-4	2	C3-C-4	SIDE LOOP C3 CAGE
-5	2	C3-C-5	STIFFENER BAR
-6	1	C3-C-6	BUMPER BRACKET
-7	2	C3-C-7	BOSS

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL SHARP C-3 FILET AROUND ALL PART CONNECTIONS 100%
 - 9) USE WELD FIXTURE C-3 FILET AROUND ALL PART CONNECTIONS 100%
 - 10) HOLES OF BOTH SETS OF 2 AND 7 MUST ALIGN
 - 11) TRIM ITEM-5 BUMPER BRACKET AS REQUIRED TO MATCH TUBE PROFILE FOR WELDING.
 - 12) INK STAMP Y/N AND SIN PER QSI 044 AFTER POWDER COAT

DESIGN	VM	VM	REV. J
DRAWN	VM	VM	SHEET 2 OF 11
CHECKED	KFT	KFT	SCALE
MFG. APPR.	WJ	WJ	NTS
APPROVED			
DATE	2019-07-10		
DART AEROSPACE LTD		HAWKESBURY ONTARIO, CANADA	
TOOL PART #		C3-C	
TITLE		C3 CAGE	
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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

DEPARTMENT/PROCESS

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

MRB (QS1042)

QTY Affected :

Sequence #:

Date :

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Root Cause

Operator ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Other/Details: